



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3319-7
Job Sheet 211408



Part No: D3319-7

Job Qty: 3 pcs

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/16/20

Job Tracking No:

Due Date: 7/27/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D3319 REV.E IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 07-06-26 JLM IPP REV:C
17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	3 pcs		7/25/20	0.17	0.29	Waterjet - Flow		on 20/07/21
110	QC 2	3 pcs		7/25/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		on 20/07/21
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S289303



Part: D3319-7

Job No: 211408

Serial No/Batch: S289303

Revision: REV.E

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/24/20

Plex 7/16/20 10:23 AM Dart.lajeunesse.marie

120 QC 8	3 pcs	7/25/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	JUL 22 2020 DAS 40
				QC 8 - 52	9-89
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
140 Small Fab - Brake NC - B4B	3 pcs	7/25/20	0.25 0.16	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	JUL 21 2020
160 Automated Welding - B4B	3 pcs	7/25/20	0.00 0.43	Automated Welding - 1 - B4B	<i>ca</i>
170 QC 10	3 pcs	7/25/20	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	DAS 24
				QC 10 - 50	9-89
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
				QC 10 - 81	
180 QC 5	3 pcs	7/25/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	DAS 24
				QC 5 - 18	9-89
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	

				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
190	Spray Paint - 2 - B4B	3 pcs	7/27/20	0.00 0.50	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
200	QC 5	3 pcs	7/27/20	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
					QC 5 - 61
					QC 5 - 81
					QC 5 - 82
210	Packaging 3-1 - Stock - B4B	3 pcs	7/27/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B

DAS

41

9-89

JUL 27 2020

DAS

40

9-89

JUL 29 2020

DAS

28

3-89

				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
220 QC 21 - SA	3	7/27/20	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 9	DAS
				QC 21 - SA - 77	77

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: _____ Prog Rev: _____ 2-Debur if necessary

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

140 - Form using DT8326 & DT8261 as per Dwg D3319 Rev: _____

160 - 8259 Hardcoat Rod M137091

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Chemical Conversion Coat per QSI005 4.1) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE. BATCH: 5283289

200 - (QC5- Inspect part completeness to step on W/O)

210 - Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-7, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: _____

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	1.6500 sf (.55 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	2	200	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190Inches	+ 0.005 - 0.001	0.195 0.189	
2	Wearplate	0.316Inches	+ 0.006 - 0.001	0.322 0.315	
3	Wearplate	0.607Inches	± 0.010	0.617 0.597	
4	Wearplate	0.600Inches	± 0.030	0.630 0.570	
5	Wearplate	2.690Inches	± 0.010	2.700 2.680	
6	Wearplate	3.526Inches	± 0.010	3.536 3.516	
7	Wearplate	4.520Inches	± 0.030	4.550 4.490	
8	Wearplate	5.063Inches	± 0.010	5.073 5.053	
9	Wearplate	6.160Inches	± 0.030	6.190 6.130	
10	Wearplate	11.650Inches	± 0.010	11.660 11.640	
11	Wearplate	12.750Inches	± 0.030	12.780 12.720	
12	Wearplate	0.048Inches	± 0.010	0.058 0.038	
13	Wearplate	0.500Inches	+ 0.006 - 0.010	0.506 0.490	
14	Wearplate	0.504Inches	± 0.010	0.514 0.494	

Plex 7/16/20 10:23 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 211408
Description: Wearplate		Part Number: D3319-7
Inspection Dwg: D3319	Rev: C E	Page 1 of 1

DAS
35
9-89

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.190	+0.005/-0.001	Ø.193	1		Vide-04	
Ø0.346	+0.006/-0.001					
0.607	+/-0.010	.609	1		" "	
0.60	+/-0.030	.596	1		" "	
2.890	+/-0.010					
3.527"	+/-0.010	3.526	1		" "	
4.52	+/-0.030	4.518	1		" "	
5.063	+/-0.010	5.061	1		" "	
6.16	+/-0.030	6.155	1		" "	
11.650	+/-0.010 +/-0.030	11.65	1		Tap	
12.75	+/-0.030	12.75	1		"	
0.048	+/-0.010	.047	1		V: 0.04	
Ø0.500	+0.006/-0.001	Ø.502	1		" "	
Ø0.504	+/-0.010					
0.316	+/-0.010"	.317	1		" "	

DAS
35
9-89

Measured by: a	Audited by:	Preliminary Approval:
Date: 20/07/21	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	
B	13.09.10	Dimensions revised per Dwg Rev C	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



Container No: S289303



Part: D3319-7

Job No: 211408

Serial No/Batch: S289303

Revision: REV.E

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/21/20